



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2877
Job Sheet 172783



Part No: D2877

Job Qty: 50 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/6/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP B 00.05.19 Added inspect level 8 EC IPP C IPP Rev:D Now M6061-T6 06-06-23 JLM IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		3/7/18	0.00	0.00	Start Up Waterjet		PC 18/03/20
100	Waterjet	50 pcs		3/7/18	0.00	1.73	Waterjet1		PC 18/03/20
120	QC	50 pcs		3/7/18	0.00	0.00	QC8		38
130	HandFinish	50 pcs		3/8/18	0.00	0.45	HandFinish1		SA DAS 3-22
140	QC	50 pcs		3/8/18	0.00	0.00	QC7-1		11 MAR 23 2018
150	Packaging	50 pcs		3/8/18	0.00	0.00	Packaging3	Stock	OFF MAR 23 2018
160	QC21-SA	50 Ea		3/8/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2884 2-Tumble ,Deburr if necessary
Descriptions:

DAS 21
MAR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	3.0350 sf (.0607 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	3	174	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches ± 0.030	1.010 0.950		
2	Saddle Spacer	0.060Inches ± 0.030	0.090 0.030	Radius	
3	Saddle Spacer	0.300Inches ± 0.030	0.330 0.270	Radius	
4	Saddle Spacer	1.000Inches ± 0.030	1.030 0.970		
5	Saddle Spacer	0.250Inches ± 0.030	0.280 0.250		
6	Saddle Spacer	0.257Inches ± 0.005	0.262 0.257	Diameter	
7	Saddle Spacer	0.125Inches ± 0.005	0.130 0.120	thick	

Plex 2/21/18 4:06 PM Dart.Gagnon.Michelle



Container No: S053543



Part: D2877

Job No: 172783

Serial No/Batch: S053543

Revision:

Inspector:

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Date: 03/21/18